

Work Order ID 51771

September 3, 2009 7:23:33 AM



Page 1

Item ID: D3140-301

Accept



Setup Start



Revision ID: F

Stop



Item Name: Doubler

Start Date: 9/03/09 Start Qty: 3.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: *CL*

Date: *09/09/03* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3140

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3140 ☒ Dwg Rev: *F* ☐ Prog Rev: *F* ☐ 2-
Deburr if necessary

HB 9-9-3

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-9-3

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 809/03



f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51771

September 3, 2009 7:23:33 AM



Page 2

Item ID: D3140-301

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Setup Start



Revision ID: F

Stop



Item Name: Doubler

Start Date: 9/03/09

Start Qty: 3.00



Cust Item ID:

Required Date: 9/04/09

Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Scuff surfaces with 80grit sandpaper per QSI 006□2-Deburr.□ No sharp edges

M.L. 09/04/04

(4X)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

4

105054

150

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

LF 09-09-8 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51771

September 3, 2009 7:23:33 AM

Page 3

Item ID: D3140-301

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Revision ID: F

Item Name: Doubler

Setup Start

Stop

Start Date: 9/03/09 Start Qty: 3.00

Required Date: 9/04/09 Req'd Qty: 3.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

Handwritten initials

09/04/08

(XF)

0

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

0.00

09/05/08 (4)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/09/08
ME 09-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 3, 2009 7:23:32 AM

Work Order ID: 51771

Parent Item: D3140-301RevF

Parent Item Name: Doubler

Comments:

Start Date: 9/03/09

Required Date: 9/04/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	114.4414	8.7717	(4)		
										11.6956		
												B 9-9-3
6061-T6 .063 Sheet												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	114.4414211	
110551	114.441421	

110551

(4)

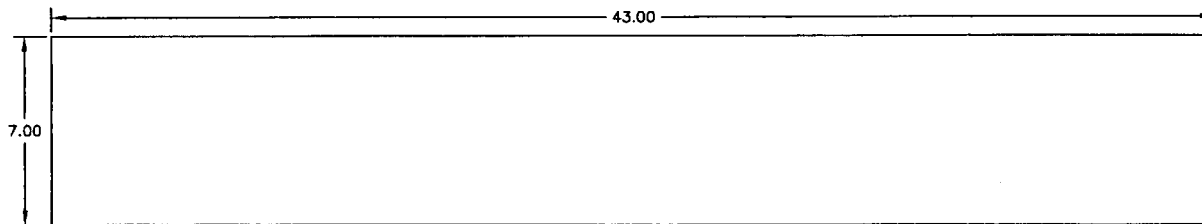
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

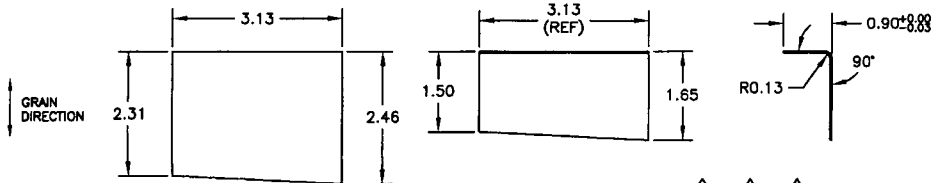
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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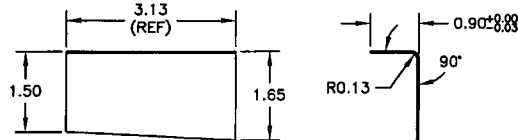
NOTE: Date & initial all entries



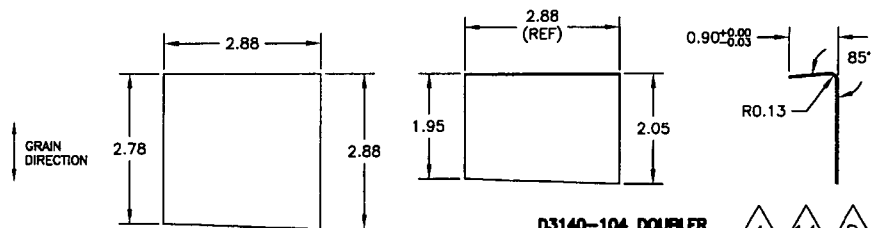
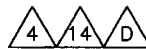
D3140-87 DOUBLER
 (REPLACES PREMIER P/N B30-23000-87)



D3140-105F FLAT PATTERN
 (USED TO MAKE D3140-105/-106 BRACKETS)

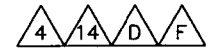


D3140-105 DOUBLER
 D3140-106 OPPOSITE

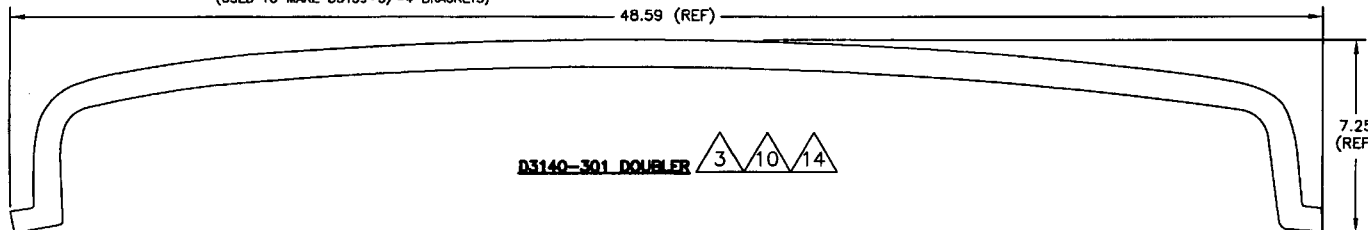


D3140-103F FLAT PATTERN
 (USED TO MAKE D3140-103/-104 BRACKETS)

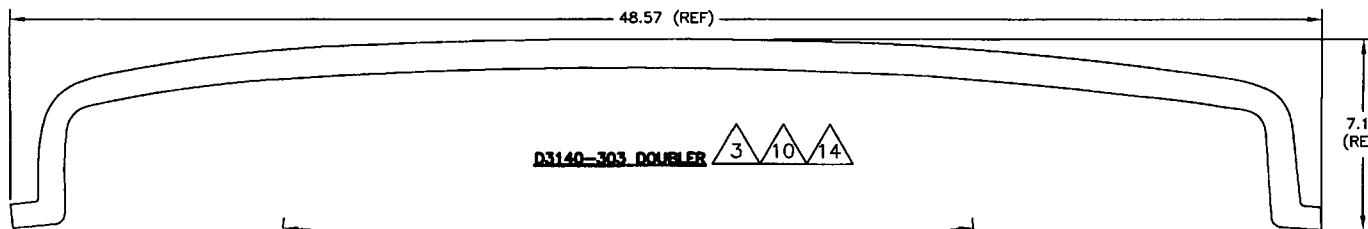
D3140-104 DOUBLER
 D3140-103 OPPOSITE



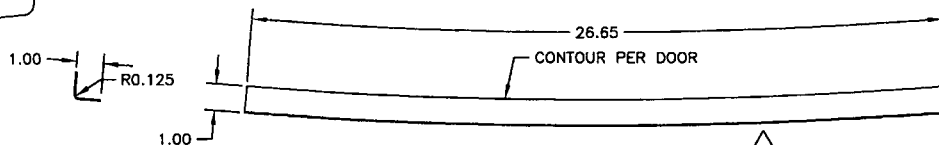
D3159-3F FLAT PATTERN
 (USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER



D3140-303 DOUBLER



D3140-85 ANGLE
 FLAT PATTERN: 26.65" x 1.90"
 (REPLACES PREMIER P/N B30-23000-85)

RELEASED

06.11.13

C209109103
 W10: 51771

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				SCALE	NTS